

Work Order ID 128949

128949

Page 1

Tuesday, January 27, 2015 7:55:05 AM

Item ID: D3319-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Forward Wearplate

Start Date: 1/26/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1501-29 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								

100 FLOW WATER JET 0.00

100

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3319

Dwg Rev: C

Prog Rev: C

2-Debur if necessary

1010.050"

12 0 Jm 15-2-10

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

Quality Control

12 0 Jm 15-2-10

120 QC8- Inspect parts - second check 0.00

120

QC

Memo

Quality Control

(12) 0 DAS 38 9-89 FEB 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 128949

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Tuesday, January 27, 2015 7:55:05 AM

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Forward Wearplate
 Start Date: 1/26/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC	NC BRAKE	0.00			00 30 989	12			15/02/23
Brake NC	Memo 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>C</u> 2- Form flat on press using DT8776 block	0.00							
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00				(12)			DAS 38 9-89
Quality Control	Memo	0.00							FEB 24 2015
160 *160* Large Fab	Weld per dwg A/R Hardcoat steel Batch: <u>131416</u>	0.00				12			15-03-16
Large Fab	Large Fab	0.00							PK
	Memo 1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: _____ Qty Part Number Description Batch A/R N/A 228/7560 Hardcoat Rod _____								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128949

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Tuesday, January 27, 2015 7:55:05 AM

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Forward Wearplate
 Start Date: 1/26/15 Start Qty: 12.00 ***12*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 24 9-89
170						12			MAR 19 2015
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							DAS 24 9-89
180						12			MAR 19 2015
QC	Memo	0.00							
Quality Control									
190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
190	Memo	0.00				12	15-3-19		24 9-89
Powdercoat	START TIME: 2:10								
Powder Coating	OVEN TEMPERATURE: 320								
	FINISH TIME: 3:10								

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Picklist Print

Tuesday, January 27, 2015 7:55:04 AM

Page 1

Work Order ID: 128949

128949

Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S18GA

Purchased

No

100

sf

201.3542

0.628

7.932631

M1010S18GA

8

Jm15-210

1010/1025 SHEET .048

Location

Loc Qty

Loc Code

MAT019

201.354152

124428

11

m130454

30.3542

m131353

160

124428

DQA: _____ Date: _____



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FAULT CATEGORY

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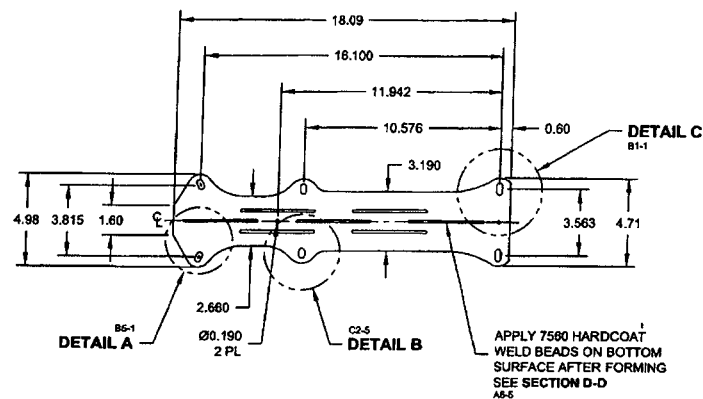
DART AEROSPACE LTD		Work Order: 128949
Description: Wearplate		Part Number: D3319-1
Inspection Dwg: D3319	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

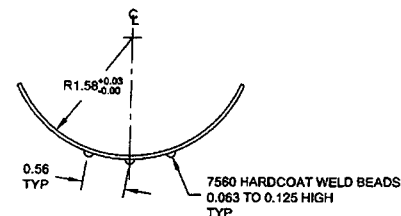
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.98 ^u	-		V	Jkmo1
1.600	+/-0.010	1.600 ^u	-		V	
2.660	+/-0.010	2.660 ^u	-		V	
3.190	+/-0.010	3.190 ^u	-		V	
3.563	+/-0.010	3.563 ^u	-		V	
4.71	+/-0.030	4.71 ^u	-		V	
0.60	+/-0.030	0.60 ^u	-		V	
10.576	+/-0.010	10.576 ^u	-		V	
11.942	+/-0.010	11.942 ^u	-		V	
18.09	+/-0.030	18.09 ^u	-		T	Jkmo7
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	Ø0.316 x 0.546 ^u	-		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	Ø0.316 x 0.670 ^u	-		V	
Ø0.190	+0.005/-0.001	Ø0.191 ^u	-		V	
3.815	+/-0.010	3.815 ^u	-		V	
16.100	+/-0.010	16.100 ^u	-		T	

Measured by: Jm	Audited by: 38 9-89	Preliminary Approval:
Date: 15-2-10	Date: FEB 12 2015	Date:

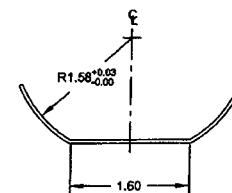
Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



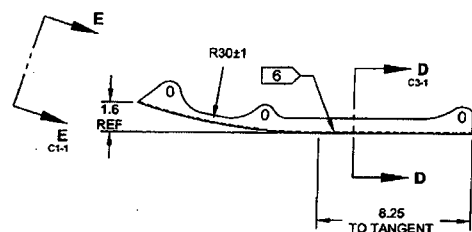
D3319-1F FLAT PATTERN



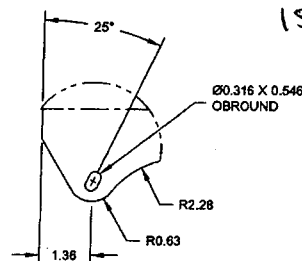
SECTION D-D
SCALE 4X



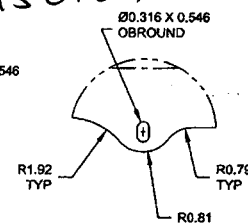
SECTION E-E
SCALE 4X



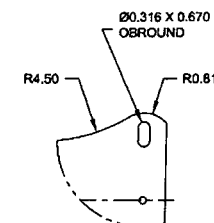
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-03-16
PER ECN 12-946 R12.03.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT MOST HOLE ON -3/5-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3319

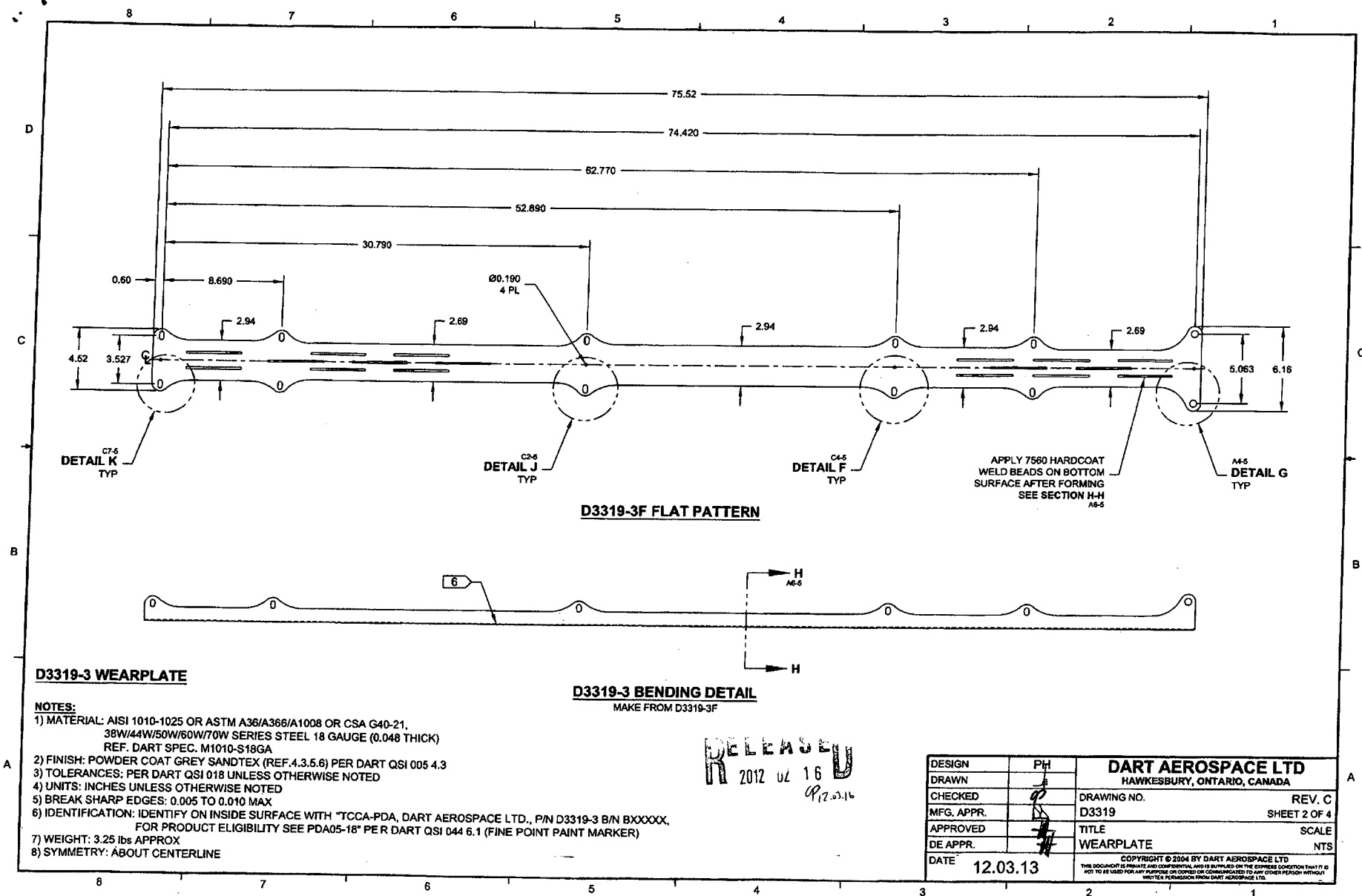
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WEARPLATE

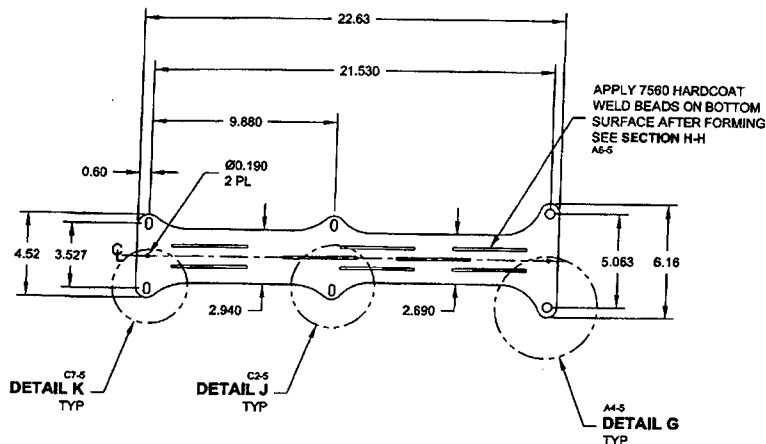
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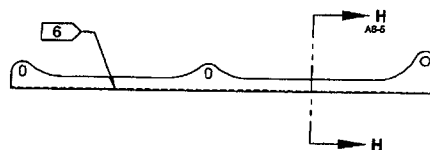
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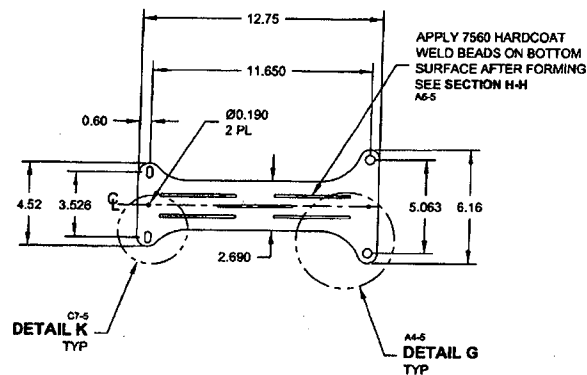
RELEASE
2012 02 16
CP 12.03.14



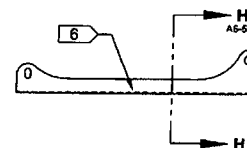
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

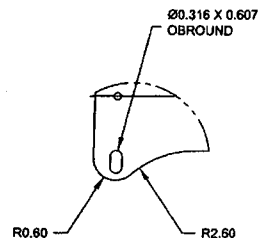
D3319-5/-7 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANITEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

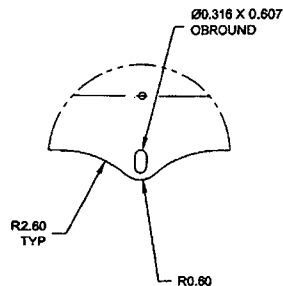
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2012-02-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3319	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
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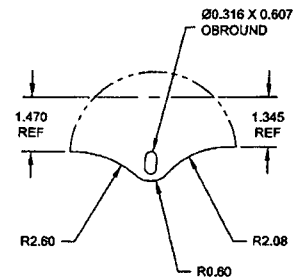
DETAIL K
SCALE 2X

B8-2
C4-3
C6-3



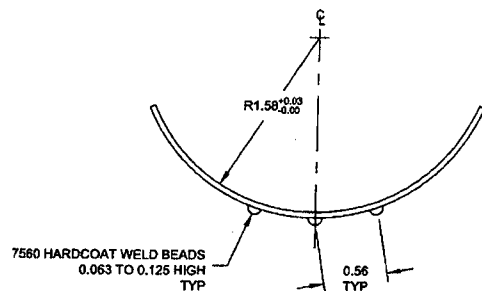
DETAIL F
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B8-2



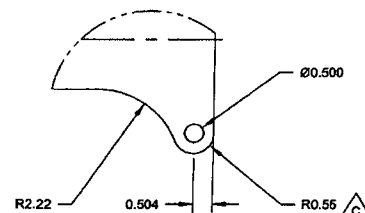
DETAIL J
SCALE 2X

B8-2
C7-3



SECTION H-H
SCALE 4X

B4-2
B3-3
B6-3



DETAIL G
SCALE 2X

B8-2
C7-3
C6-3

RELEASED
2012-02-16
P.2.03.16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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